

Date: Wednesday, 1/4/2006 2:36:48 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services		Drawing Name	: 206L BASKET LID	
Job Number	: 25389B		Part Number	: D2252043	
Estimate Number	: 11274		Drawing Number	: UNDER REVIEW D2252 REV E	
P.O. Number	: N/A		Project Number	: N/A	
This Issue	: 1/4/2006 S.O. No. : N/A		Drawing Revision	: E	
Prsht Rev.	: NC		Material	: N/A	
First Issue	: N/A		Due Date	: 1/30/2006	
Previous Run	: 23136B		Qty:	1 Um: Each	
Written By	: See COMMENT Below				
Checked & Approved By	: See ABOVE USER & DART				
Comment	: Est Rev:1 REVISED AS PER REV E 05-12-06 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M304TS0750W065	304 SQ Tube.75x.75x.065W	32.553 ¹
		Comment: Qty.: 32.5539 f(s)/Unit Total : 32.5539 f(s) 3/4" x 3/4" x 0.063 wall 304/316 SS tubing. Batch: M100003	06/03/08
2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1	06/03/08
		Comment: LARGE FABRICATION RESOURCE 1	
		1- Cut D2252-1-3-9 as per Dwg D2252	
		2-Drill hole in D2252-1 as per Dwg D2252	
		3-Deburr & Remove all Markings from Material	
3.0	D2329	Label Plate	06/03/13
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch	
		1 D2329 Label Plate B23490	
4.0	D23271	Spacer Bushing	06/03/13
		Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s) Pick: Qty Part Number Description Batch	
		1 D2327-1 Bushing B24873	

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 1/4/2006 2:36:49 PM
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Part Number: D2252043

Job Number:



Seq. #: Machine Or Operation:

Description :

5.0 D22321 Hinge



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2232-1	HINGE	B93445

②
M 06/03/08

6.0 D2581 Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D2581	Mounting Chanel	B25894

②
M 06/03/13

7.0 M304EX07516F Expanded Metal Flat Stai



Comment: Qty.: 18.9000 sf(s)/Unit Total : 18.9000 sf(s)

Pick:

Qty	Part Number	Description	Batch
18 sf	M304EX0.75-16F	Expanded Metal	M100230

1890

②
M 06/03/13

8.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

①

1-Weld as per Dwg D2252 using Welding Table and corner Jig

Deburr as required

A/R SS ROD Batch: M19555

M 06/03/08

9.0 QC5/9 WELD INSPECTION



①

Comment: WELD INSPECTION

PD 03-06-16

10.0 POWDER COATING POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

PD 06/03/16 ①

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/03/03
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number:



Seq. #: Machine Or Operation:

Description :

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Z 06.03.17

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

C 06/03/20 ①

13.0

DC

DOCUMENT CONTROL



DP 06/03/23 ①

Comment: DOCUMENT CONTROL

Inspection Level 21

Job Completion



LL 06.03.22

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

RELEASED
05.11.26

DESIGN KE	DRAWN BY MB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>✓</i>	APPROVED <i>✓</i>	DRAWING NO. D2252	REV. E SHEET 1 OF 5
DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)		SCALE NTS
C	95.12.11	RE-DRAWN	
D	99.09.14	MODIFIED LATCH, D2581 WAS D2255-3	
E	05.11.10	D2253-1 WAS D2253 (NCR 533), ADDED MEMBERS TO LID FRAME, ADDED D2232-1/-3 & D2252-19	

Qty -041	Qty -043	Part Number	Description	L	A
X		D2252-041	BASKET ASSEMBLY		
	X	D2252-043	LID ASSEMBLY		
2		D2232-1	HINGE		
2		D2232-3	HINGE		
5		D2235-1	RIB		
2	2	D2252-1	FRAME	25.50 ✓	45
2		D2252-3	FRAME	296.00 ✓	45
	2	D2252-7	FRAME	24.00 ✓	90
1		D2252-9	FRAME	10.25 ✓	90
1		D2252-11	FRAME	25.00 ✓	90
1		D2252-13	FRAME	42.00 ✓	90
1		D2252-15	FRAME	15.00	90
4		D2252-17	FRAME	19.78 ✓	53
	2	D2252-19	FRAME	95.27 ✓	45
	2	D2252-21	FRAME	30.82 ✓	90
	1	D2252-23	FRAME	30.62 ✓	90
2		D2253-1	LUG		
2		D2254	GUSSET		
	1	D2327-1	BUSHING		
1		D2327-3	BUSHING		
	1	D2329	LABEL PLATE		
4	2	D2581	MOUNTING CHANNEL		
A/R	A/R		3/4-16F EXPANDED METAL		

NOTES:

1. MATERIAL: AISI 304/316 SS 3/4 X 3/4 X 0.060 WALL SQUARE TUBE
(REF. DART SPEC. M304TS0.750W.060)
2. FINISH: POWDER COAT ASSEMBLY GLOSS WHITE (4.3.5.2) PER DART QSI 005 4.3
3. WELD PER DART QSI 004
4. ALL DIMENSION ARE IN INCHES
5. TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.

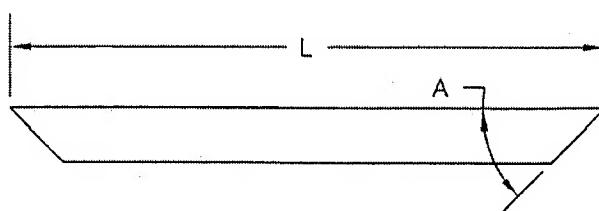
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NOV 17

25389 B



CUT SIZE DETAIL

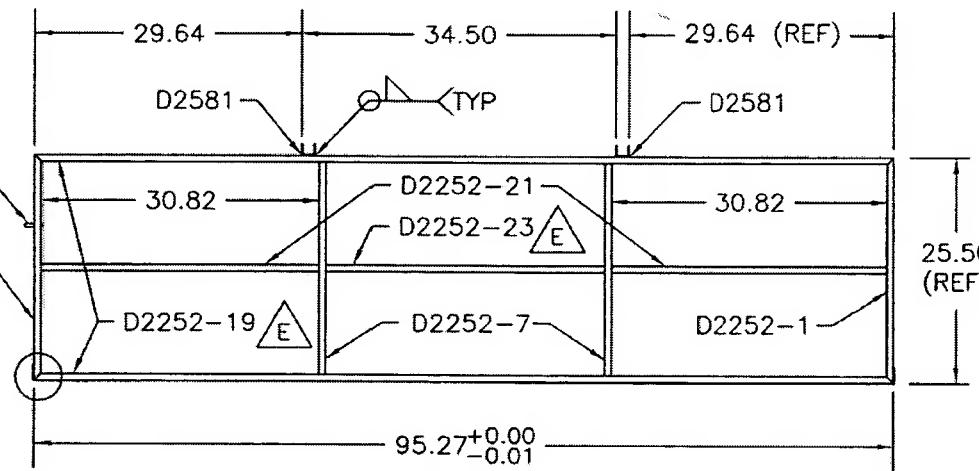
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CHECKED	APPROVED	D2252		SCALE
DATE		05.11.10	TITLE	NTS
			BASKET ASSEMBLY (206L)	



TYP TYP
WELD ALL JOINTS AS SHOWN

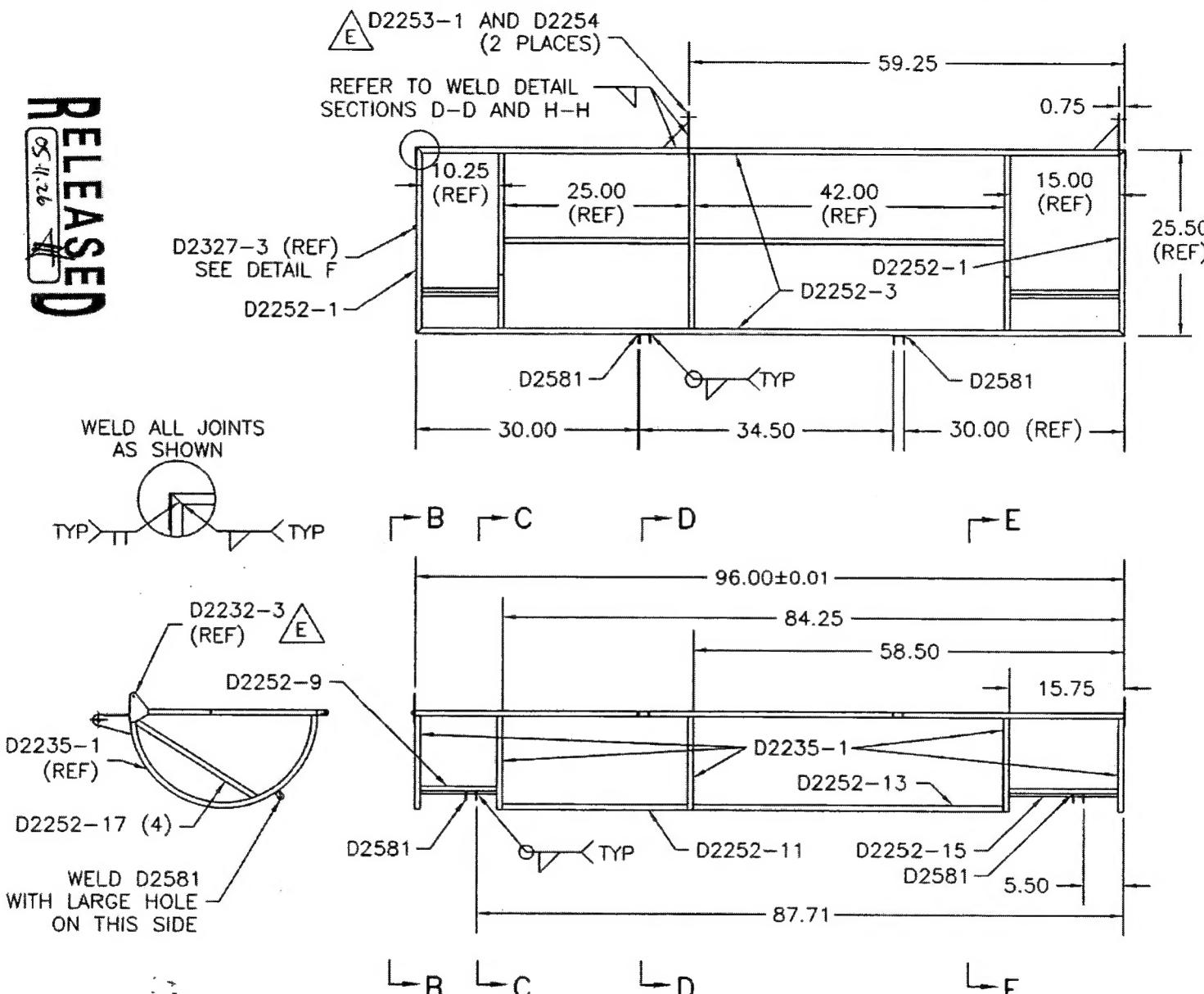
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TO A VENDOME
NOTICE
ORDER
25389E

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		D2252
		WEEK
		3 OF 5
		REV. E
		SCALE
		NOTES

RELEASED
05.11.26D2252-041 BASKET FRAME

1. COPY
2. ENTHOLD
3. NOTE
4. ORDER

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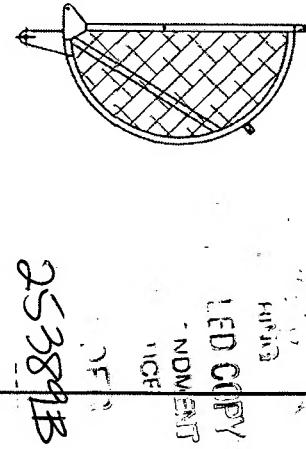
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DATE 05.11.10	TITLE BASKET ASSEMBLY (206L)		SHEET 4 OF 5
			SCALE N/T/S

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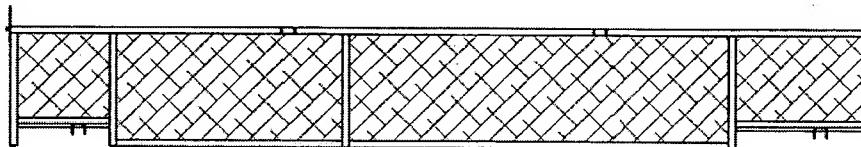
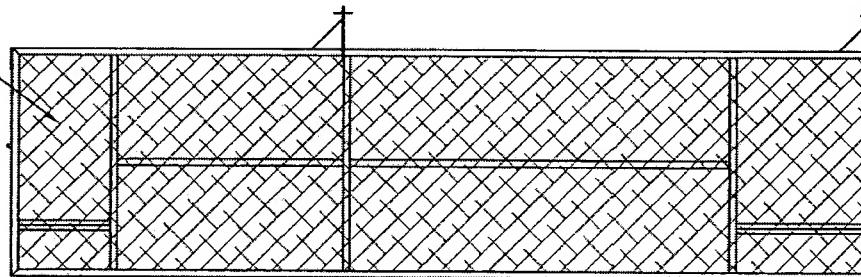
25389B

LED COPY
- DOCUMENT
VICE

D2329 LABEL PLATE
CENTER ON THE
BASKET LID

— REMOVE 2" X 6" SECTION
OF MESH FROM BEHIND
LABEL PLATE

D2252-043 LID ASSEMBLY



D2252-041 BASKET ASSEMBLY

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2 TO AMENDMENT
ROUT NOTICE
WORK ORDER
75393

SKIN ROW
TO
ROUTINE

Technical drawing of a structural component labeled 'E'. The drawing shows a horizontal bar with a vertical slot. A dimension of 11.00 is given for the width of the slot. A dimension of 1.72 is given for the height of the slot. The drawing is labeled 'D2232-3 (TYP BOTH ENDS)' and 'SEE D258 (REF)'.

VIEW A-A

DRILL 3/8 HOLE AND
INSTALL D2327-1/-3
SEE DETAIL F

10

RELEASER
05.11.26 - 11

The diagram shows a cross-section of an expanded metal mesh. The mesh is depicted as a series of parallel, slightly curved horizontal lines. At the top and bottom edges, there are vertical columns of squares, which are the expanded metal strips. The central area is filled with a grid of smaller squares, representing the expanded metal mesh itself. A horizontal line with arrowheads at both ends, labeled 'SECTION E-E', passes through the center of the mesh. The label 'EXPANDED METAL' is positioned at the top left of the diagram. A small reference mark 'D258 (REF)' is located in the bottom right corner.

DETAIL F

SPACER INSTALATION

Technical drawing of an aircraft section C-C. The drawing shows a curved skin panel labeled 'SKIN'. A dimension line indicates a height of 0.46 from the bottom of the skin to a reference point labeled 'D2581 (REF)'. Another dimension line shows an angle of 53° from the skin to a vertical line. The label 'POSITION USING T2252WJ-1' is present.

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DESIGN	DRAWN BY	REV. E
KE	MB	SHEET 5 OF 5
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05.11.10	BASKET ASSEMBLY (206L)	NTS

